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SECURITY INFORMATION  
CENTRAL INTELLIGENCE AGENCY

REPORT NO. [REDACTED]

## INFORMATION REPORT

CD NO. [REDACTED]

25X1A

COUNTRY East Germany

DATE DISTR. 22 June 1953

SUBJECT Large Enamelled Containers Produced at SAG  
Marten, Eisen- und Huettenwerke, Thale

NO. OF PAGES 3

PLACE  
ACQUIRED [REDACTED]NO. OF ENCLS.  
(LISTED BELOW)

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DATE OF  
INFO. [REDACTED]SUPPLEMENT TO  
REPORT NO. [REDACTED]

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Note: This report provides details on large enamelled containers made at the SAG Marten plant EHW/Thale. Throughout the report, the German designation "Stutzen" is used for the short lengths of feed pipe which are welded to the various containers.

1. Wine tanks (Weintanks). All "Wine Tanks" made at EHW/Thale have been of the same capacity, and all have been made of 10 mm sheet iron. Each wine tank contains:
  - a) one feed pipe (Stutzen) welded at one end, top center, located exactly on the welding seam where the end piece is welded to the main cylindrical body. This Stutzen is called the air-removal pipe (Entlueftungsstutzen). It is about 5cm in diameter and 7 or 8 cm long. It is fitted at the outside end with a flange ring which has been pressed out of the main body of the pipe (i.e., it is not added afterwards by welding). This flange contains four holes to receive machine screws for attaching the actual air valve. This and the other valves for EHW containers are made at the Quedlinburg Messgeraetewerk. The valve does not consist of a faucet, nor does it have any screwing arrangement for opening and closing. It consists of a disk of rubber fastened to a star-shaped piece of metal, floated in a cylinder. This disk is so arranged that it can move slightly inwards, perhaps one centimeter; a spring arrangement normally keeps it pressed against a frame.
  - b) At the opposite end of the tank from the Stutzen described in the previous paragraph, there is located, also top center, a feed pipe for filling the tank (Einlaufstutzen). It is about 20cm in diameter and 10cm long; it is fitted with a flange ring at the outside end with holes for receiving machine screws. It is welded to the tank at the welding seam where the end has been welded to the body.
  - c) On the same end as the Einlaufstutzen, but located bottom-center, is a feed pipe for emptying the tank (Auslaufstutzen), with the same dimensions and characteristics as the former. Between these two pipes runs a plain glass tube about 2.5cm in diameter, without markings, to show the contents in the container.
  - d) All three feed pipes described above are enamelled on the inside.

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At the same end of the tank as the above-mentioned filling-and emptying leads, a man-hole is located in the center of the end-piece; it has an oval shape. The hole is about 60cm wide and 35-40cm high. It is fitted with a cover attached to the inside of the container. The cover is also fitted with a rubber gasket to allow for a tight fit. The cover opens inward and is provided with a spring which normally keeps it shut. In addition, the cover can be sealed tight with a bolt about one inch in diameter and a six-sided nut. This nut must be tightened with a wrench.

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2. Cider Tanks (Mosttanks). These tanks are exactly the same as the wine tanks in shape and in openings; the only exception is that they are five meters long instead of 4-4.5 meters. The end pieces on both wine and cider tanks are the shape of a flattened dome (calotte).
3. "Jet Planes" (Duesenjaeger). These containers have the following feed-pipes (Stutzen) and openings; they have a volume of 15,000 liters and are made of 20 mm sheet iron:
  - a) At regular intervals and in a straight line running from one end of the container to the other, is located a series of five feed-pipes. They are 15cm in diameter and 20cm long. Each is fitted with a flange ring with an over-all diameter of about 25cm. Nothing is attached to these feed-pipes at EHW/Thale.
  - b) Three iron legs (Pratsen) are welded to the concave end of the container, allowing the presumption that they are meant to stand on that end. An attempt, however, to place such a container on end in this way at EHW/Thale resulted in tipping it over. The conclusion drawn was that a firmer foundation is ultimately intended for these containers - perhaps a base-work made of cement.
  - c) Screwed into one end of the container is a truncated funnel, forming the concave end mentioned above. The outside dimension of the funnel is the same as the diameter of the container. The hole at the bottom of the funnel is 20cm in diameter, and is not fitted with a cover, but with a stuffing box (Stopfbochse). Around the outside edge of this hole is a flange ring containing a number of holes drilled to a depth of 2cm and threaded. It is not known what is intended to be screwed onto this hole.
  - d) On the side of the above funnel, at the concave end of the container, there is located a man-hole, 50cm in diameter, fitted with a cover on the outside. The cover has a rubber gasket and can further be sealed tight by means of a movable bolt which fits into a slit in the cover. The cover is hinged onto the funnel.
  - e) A series of five feed pipes are welded around the base of the above funnel, close to the point at which the funnel is attached to the main body of the container. These feed pipes are 7 to 8cm in diameter and 10-12cm long. Each is fitted with a flange ring at the outside which has an over-all diameter of 15cm.
  - f) At the other end of the container, there is welded to the container, a conical end piece. At the tip of this end piece, there is attached a feed-pipe 30cm in diameter and 15cm in length, with a flange ring having an over-all diameter of 35cm.
  - g) A series of 11 or 12 feed pipes are welded to the side surface of the above conical end piece, in circular rows, the largest number in the row nearest to the main body of the container. These feed-pipes are elbow-shaped (called Kniee in German). They have a diameter of 30-35cm, and each half of the elbow is 30cm in length. Each is fitted with a flange ring at the far end of the feed pipe. The elbows are not square but curved. It is not known in which direction the elbows point with respect to the body of the container.
  - h) All the above feed pipes are enamelled on the inside.
4. Large agitating kettles (Grosse Rührwerkskessel). The largest agitating kettles made at EHW/Thale for the USSR have a capacity of 7,000 liters. An order for five still has not yet been finished. They are made of 3cm iron, and they all are provided with an external jacket made of 10 mm iron. The kettle itself is enamelled on the inside but not the envelope. A space of about 5cm is left between the envelope and the kettle. The envelope is welded to the kettle around the top edge only. The kettle is round, with a slightly curved bottom, and stands on three legs. The kettle contains the following openings:
  - a) One feed-pipe is welded to the top edge, just below the welding seam whereby the envelope is attached to the kettle. This pipe is 5cm in diameter and 10cm long, with a flange ring.

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- b) One feed-pipe is welded to the bottom (centrally located) of the envelope; it does not penetrate to the kettle itself. This pipe is 20cm in diameter and 10cm long, with a flange ring of 25cm diameter. A cover is provided for the kettle; it has a flattened-dome appearance. It is screwed onto the kettle with 70 to 100 screws around the edge. An asbestos gasket is provided to make a tight fit between the cover and the kettle.

The cover is fitted with the following openings:

- i) Six feed pipes are welded around the edge of the cover, four of them 10cm in diameter and 15-20cm long, the other two being 20cm in diameter and 15-20cm long. Both kinds are equipped with flange rings. They are enamelled on the inside.
- ii) On the top of the cover, centrally located, is a hole with a flange ring running around it 30cm in diameter, designed to receive a stuffing box (Stopfbüchse).
- iii) On one side of the cover is a man-hole 50cm in diameter, with a cover on the outside. This cover is screwed over the hole.

These kettles are tested with steam at EHW/Thale before shipment.

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